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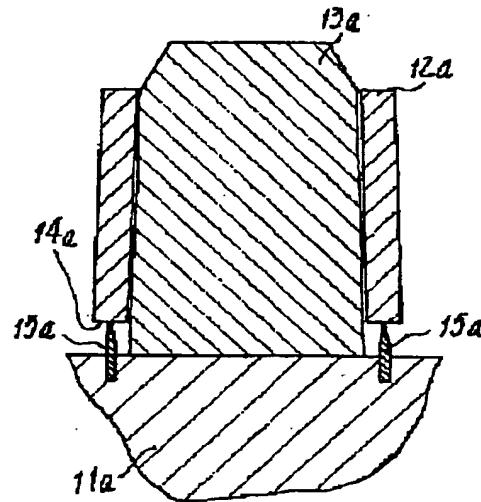
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TITLE : PATTERN AND MOLD FOR MOLDING



ABSTRACT : PROBLEM TO BE SOLVED: To reduce the damage of a sleeve and to obtain a good quality casting without sand mark by separating the heat insulating sleeve for feeder head from a casting pattern and holding.

SOLUTION: Firstly, the lower end 14a of the heat insulating sleeve 12a for feeder head covered on a positional member 13a is supported with pins 15a projected from the casting pattern 11a, and the lower end 14a of the sleeve is forcedly separated from the pattern 11a. At the time of filling up molding sand in there, the molding sand is inserted even in the gap between the lower end 14a of the sleeve and the pattern 11a. Thereafter, at the time of compressing the molding sand, since the pins 15a are gradually stuck into the lower end 14a of the sleeve, the compressed force is absorbed and the heat insulating sleeve 12a is hardly broken. Further, since the molding sand in the gap between the lower end 14a of the sleeve and the pattern 11a is sufficiently hardened, the dropping of the molding sand in a process after separating from the mold and the wash-away at the time of pouring are eliminated.

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